
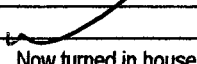


Date: Wednesday, 10/4/2006 10:56:58 AM
 User: Eric Charbonneau

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : CLAMP
Job Number : 28823	
Estimate Number : 11966	
P.O. Number : N/A	Part Number : D2055
This Issue : 10/4/2006 S.O. No. : N/A	Drawing Number : D2055 C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 10/3/2006 Type : RMA	Drawing Revision : C1
Previous Run : N/A	Material : N/A
Written By : 	Due Date : 10/16/2006 Qty: 30 Um: Each
Checked & Approved By : 	
Comment : Est. C 02.03.07 Now turned in house NG	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6R1000	ROUND BAR 1.00"
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Comment: Qty.: 0.1094 f(s)/Unit Total : 3.2823 f(s)

ROUND BAR 1.00"

Material : 6061-T6 rod (QQA-A-225/8)

Batch: M101417

06/10/04

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

HARDINGE CNC LATHE SMALL

Machine as per Folio FA203

Tumble & deburr all sharp edges as per dwg

06/10/04

30

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT PARTS AS THEY COME OFF MACHINE

06/10/05

30

4.0	QC8	SECOND CHECK
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Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

SECOND CHECK

06/10/15

30

5.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

CONVENTIONAL MILLING MACHINE

Drill hole as per dwg D2055

06/10/15

30

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: CLAMP

Job Number: 28823

Part Number: D2055

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT WORK TO CURRENT STEP

En 06/10/16

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

am 06/10/17 (30)

8.0

POWDER COATING

POWDER COATING



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

M100700

am 06/10/19 x 30

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

INSPECT POWDER COAT/CHEMICAL CONVERSION

OB 06/10/23 (30)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: Setup: 0.00Hrs/ Run: 0.0000Min Total Run : 0.0000Hrs

PACKAGING RESOURCE #1

Identify and Stock

Location: ST019

OB 06/10/23 (30)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: Setup: 0.00Hrs/ Run: 0.0000Hrs Total Run : 0.0000Hrs

FINAL INSPECTION/W/O RELEASE

OB 06/10/23

Job Completion

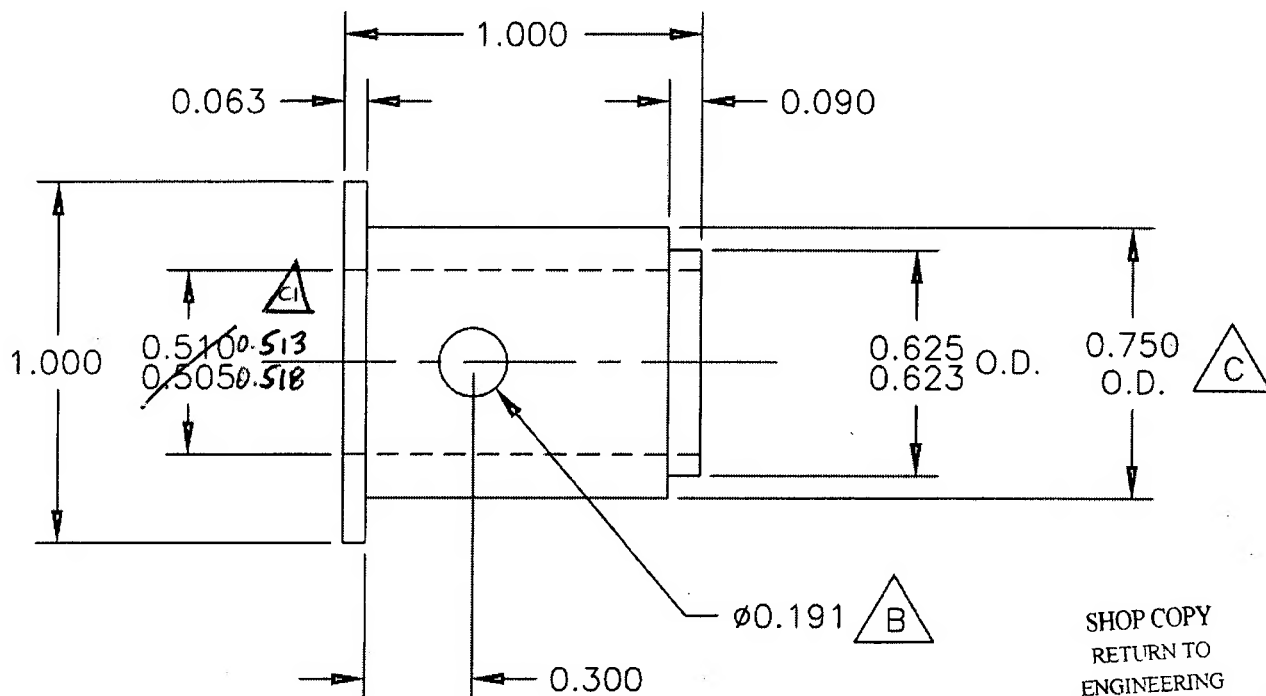


u 06.10.23



DESIGN JB		DRAWN BY CP		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED KE		APPROVED SH		DRAWING NO. D2055	REV. C SHEET 1 OF 1
DATE 98.12.10				TITLE CLAMP	SCALE 2:1
A	92.03.13		NEW ISSUE		
B	98.10.15		0.191 DIA WAS 0.187 DIA (TSR A1100) REDRAWN, ADD FINISH		
C	98.12.10		ADDED 0.750 O.D. DIMENSION		
CI	CP	01.06.05	MODIFY HOLE SIZE, ADD P/LC OPTION		

RELEASED
98.12.10 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 28823



ACID ETCH + ALODINE PER
DART QSI 005 4.1
POWDER COAT BLACK SHADTEX (4.3.7)
PER DART QSI 005 4.3

MATERIAL: 6061-T6 ROD (QQ-A-225/8)
FINISH: BLACK ANODIZE OR
BREAK ALL SHARP EDGES 0.015 MAX
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

